Work Order ID 68138

Thursday, April 07, 2011 7:41:43 AM

Item ID: D2600-3-BENT **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Extrusion Bent

Start Date: 4/7/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 4/12/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Approvals: **Process Plan:** W **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2600	Rev D1
D2750	F

100 0.00

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo 0.00

Pick qty 1 D2600-3-120 extrusion

1-Deburr one end of extrusion

2-Bend using CNC bending machine as per program 2750.C and Folio 14 use bending aid DT9635

3- cut fwd end of tube as per dwg D2750

4- cut aft end of tube as per dwg D2750

BB 11/04/19

DP 11-4-19 10

110 QC5- Inspect part completeness to step on W/O 0.00

QC

Quality Control

Memo 0.00

1 Ø BE 11/04/19 10

Work Order ID 68138

Thursday, April 07, 2011 7:41:43 AM

Item ID: D2600-3-BENT **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Extrusion Bent

Start Date: 4/7/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 4/12/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: LG	0.00				10	0		11/04/19
Packaging	**Memo**	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							11/4/19
QC	**Memo**	0.00							
Quality Control									

MF

11-04-19

Picklist Print

Thursday, April 07, 2011 7:41:41 AM

Work Order ID: 68138

Parent Item: D2600-3-BENT

Parent Item Name: Extrusion Bent

Start Date: 4/7/2011 **Required Date:** 4/12/2011

Start Qty: 10.00 **Required Qty:** 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-120		Manufactured	No			100	Each	33.0000	1	10			

Extrusion Round 3" 350

Location	Loc Qty	Loc Code
HALL	23	
43960	23	
LG	10	
43960	1	
58480	9	

10

11-4-19

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED	DRAWING NO. D2600 REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION SCALE 1:1

A	97.01.21	NEW ISSUE
B	97.09.09	CHANGE MATERIAL SPEC.
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.
D	98.08.20	INCREASE MIN. UTS TO 40 KSI
D1	01.04.17	ADD PART NUMBERS & DIE NUMBERS AP

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

   MINIMUM YIELD TENSILE STRENGTH = 35 ksi
   MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
   MINIMUM ELONGATION = 8 %

   A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.

3. NO TOOLING MARKS.

4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

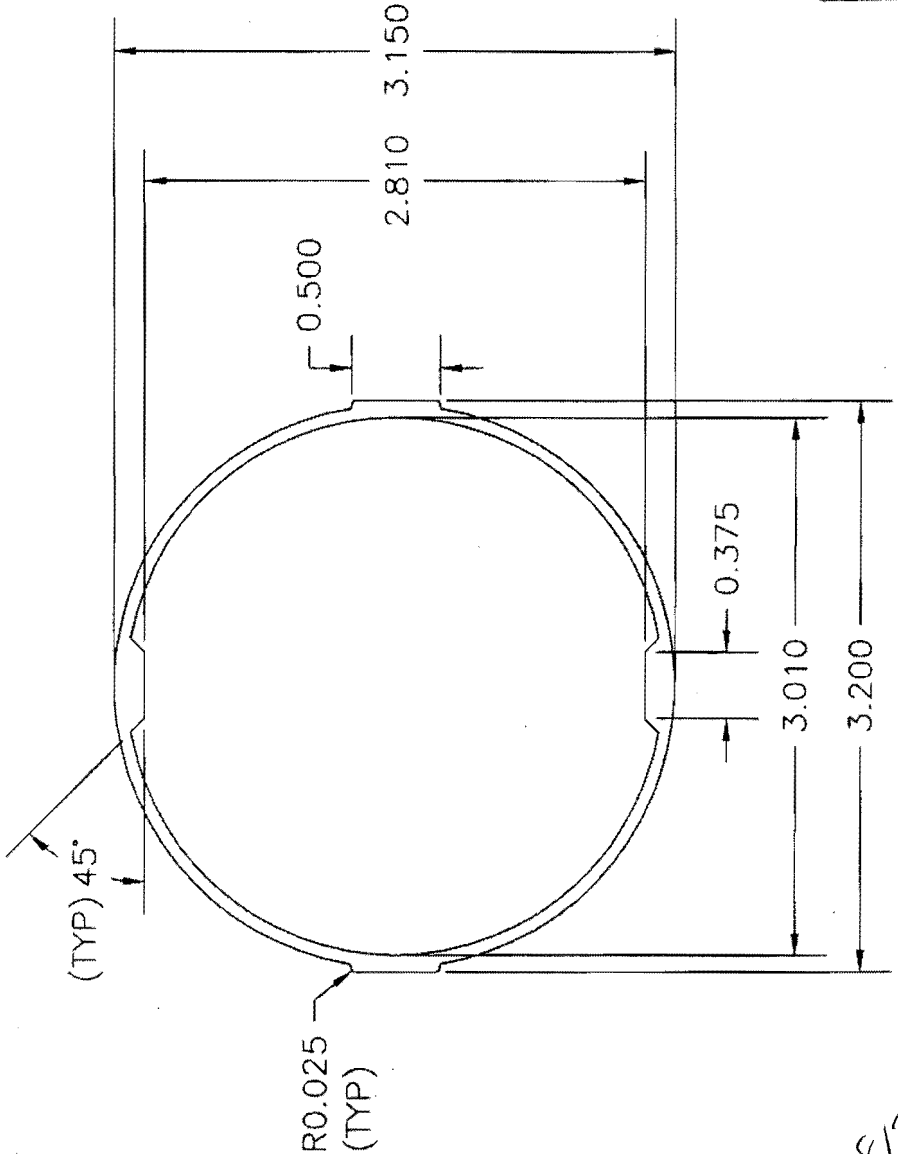
5. ALL DIMENSIONS ARE IN INCHES.

WO 64138

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

DAC COPY

RELEASED
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 877121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-YXX WHERE XX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

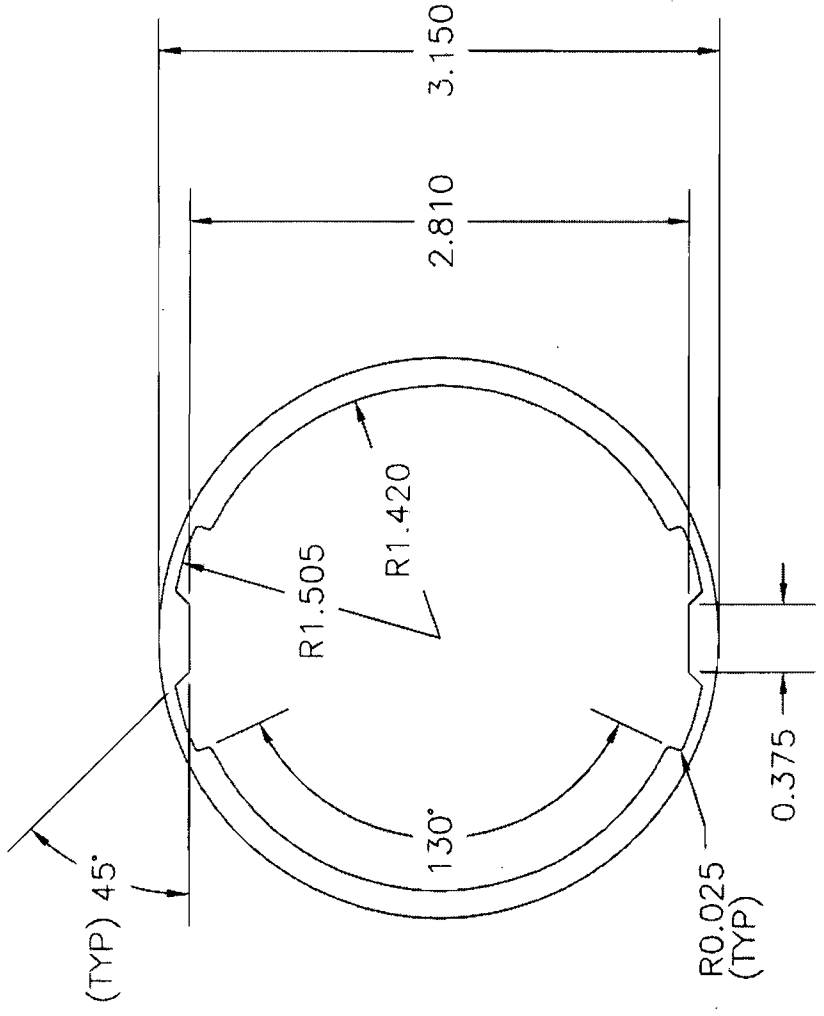
68138

DART

COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR BON L DIE # 897122 (PREFERRED CHOICE)
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)

D1

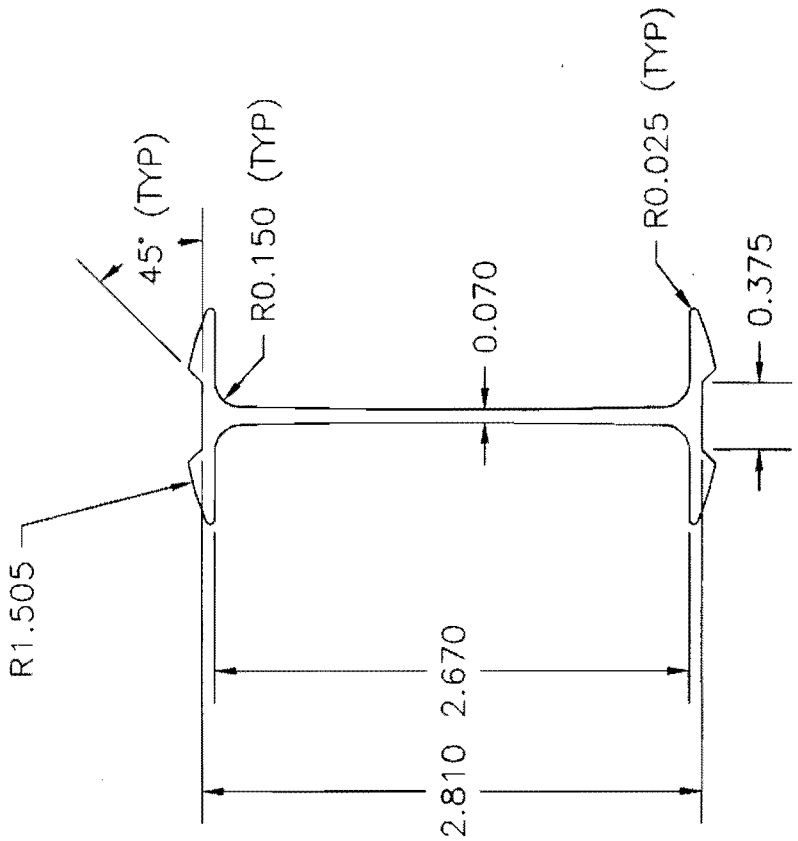
68138

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

DART

COPY ISSUED

RELEASED
98 8 25 DS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871

PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)

D1

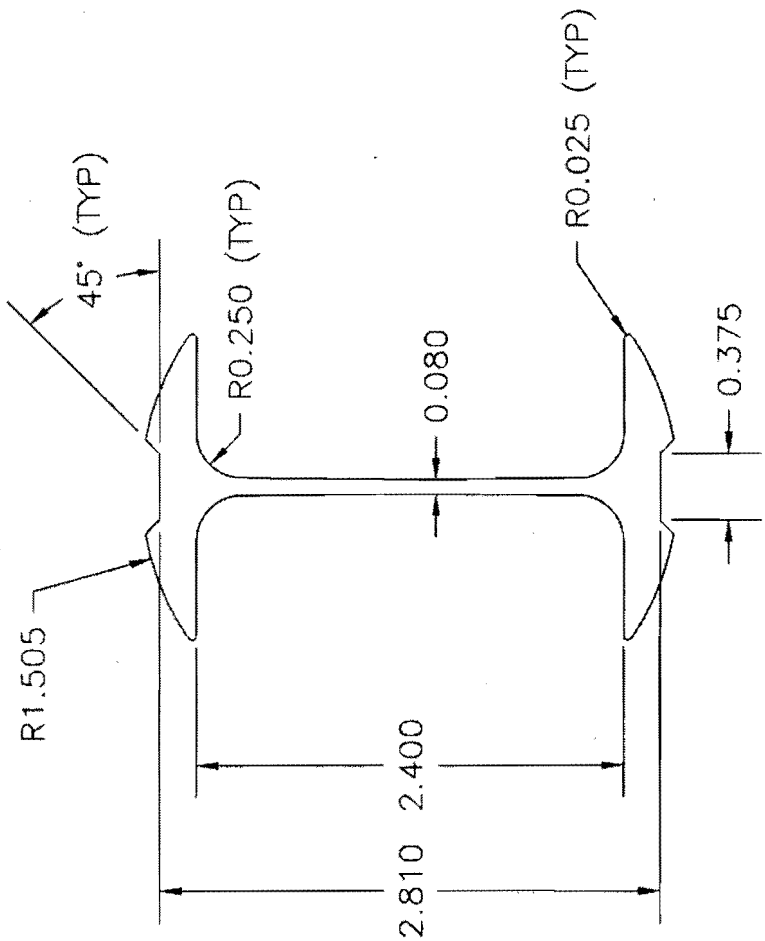
68138

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

A COPY ISSUED

RELEASED
98 8 25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872

PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 12⅝" LONG)

D1

68138

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68168

C2 11/04/19

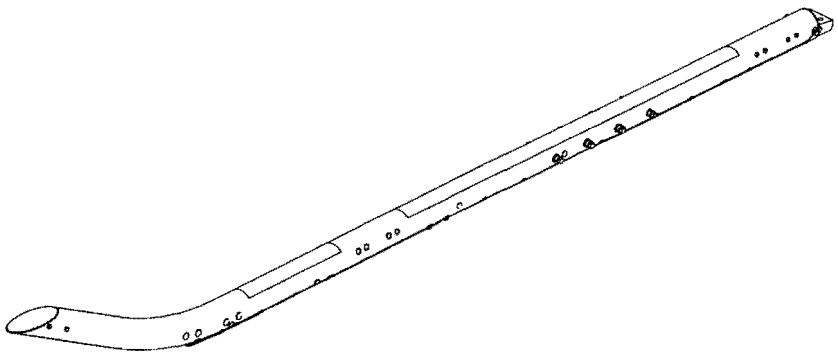
RELEASED
6 07.22.16

GENERAL NOTES:

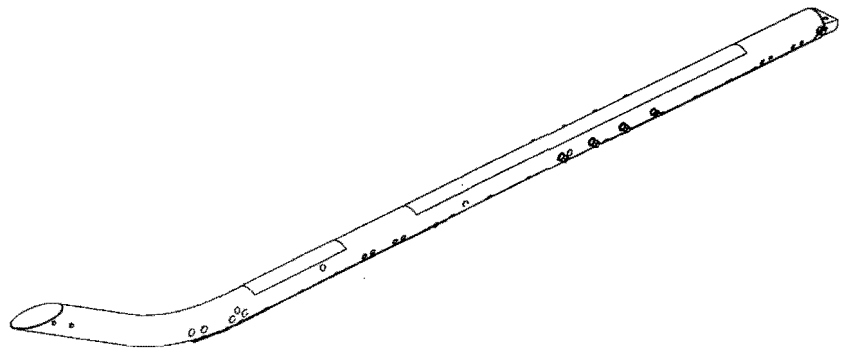
1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
2) FINISH:
   ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
   POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
8) WELD PER DART QSI 004
9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
    MINIMUM YIELD TENSILE STRENGTH = 35 KSI
    MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL (F)
13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

REV.	DESCRIPTION	BY	DATE
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3535-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16

DESIGN	PG	DART AEROSPACE USA, INC.
DRAWN	RH	PORT HADLOCK, WA
CHECKED		DRAWING NO. D2750 REV. F
MFG. APPR.		SHEET 1 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.		
DATE	08.07.16	



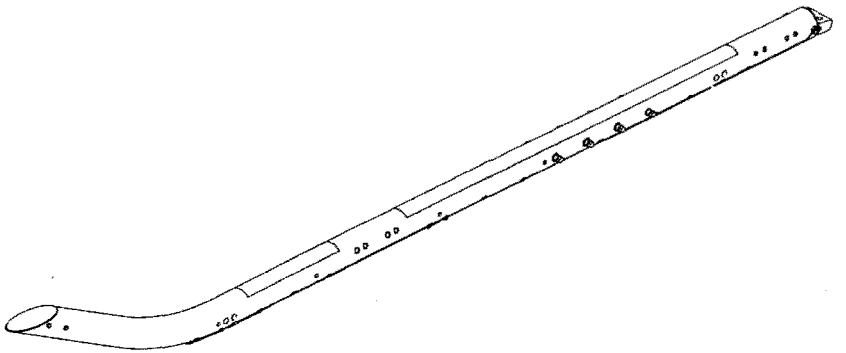
D2750-041 350 SKIDTUBE ASSEMBLY, LH



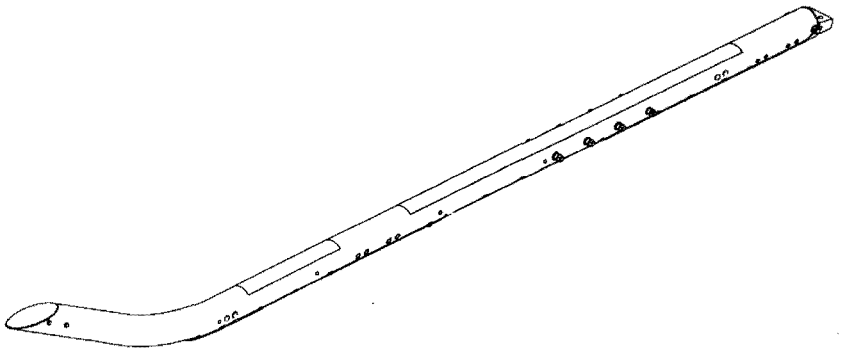
D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
08.9.22 AM

DESIGN	PGI	DART AEROSPACE USA, INC.	
DRAWN	PGI	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 2 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
DE APPR.			
DATE 08.07.16			



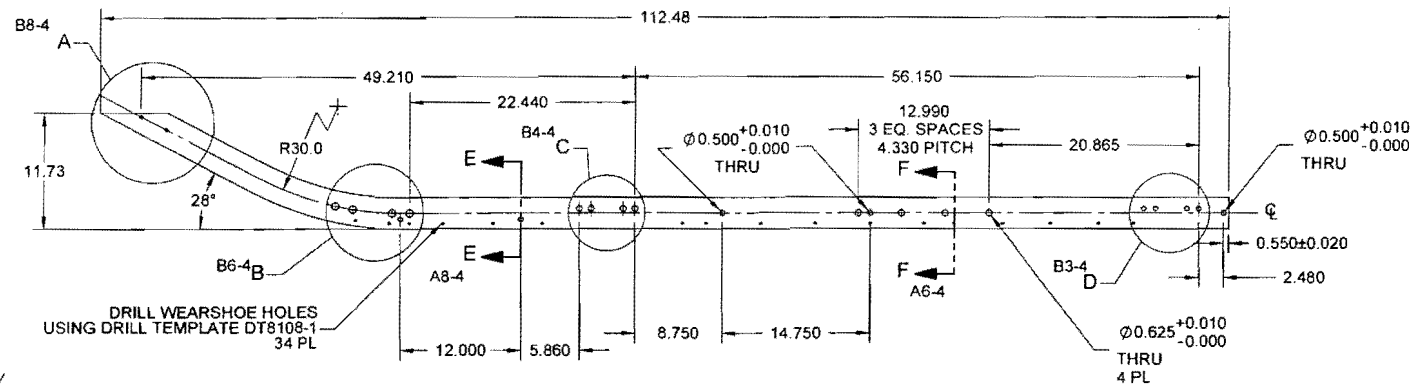
D2750-043 350 SKIDTUBE ASSEMBLY, LH



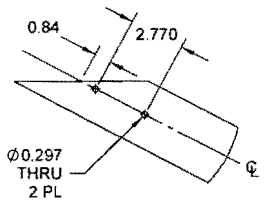
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
08-09-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 3 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16		

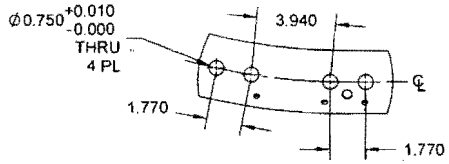


D2750-1 LH SKIDTUBE



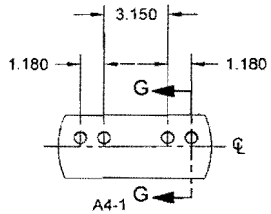
D7-4

DETAIL A
SCALE 2X



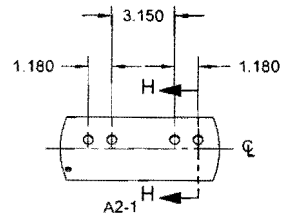
D7-4

DETAIL B
SCALE 2X



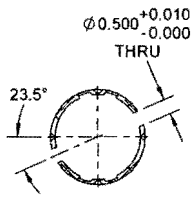
D5-4

DETAIL C
SCALE 2X



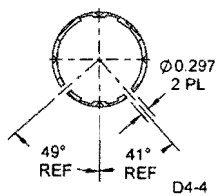
D3-4

DETAIL D
SCALE 2X



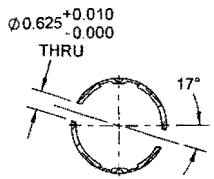
D6-4

SECTION E-E
SCALE 3X, 2 PL



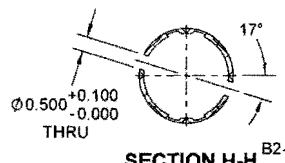
D4-4

SECTION F-F
SCALE 3X, 17 PL



B4-4

SECTION G-G
SCALE 3X, 4 PL

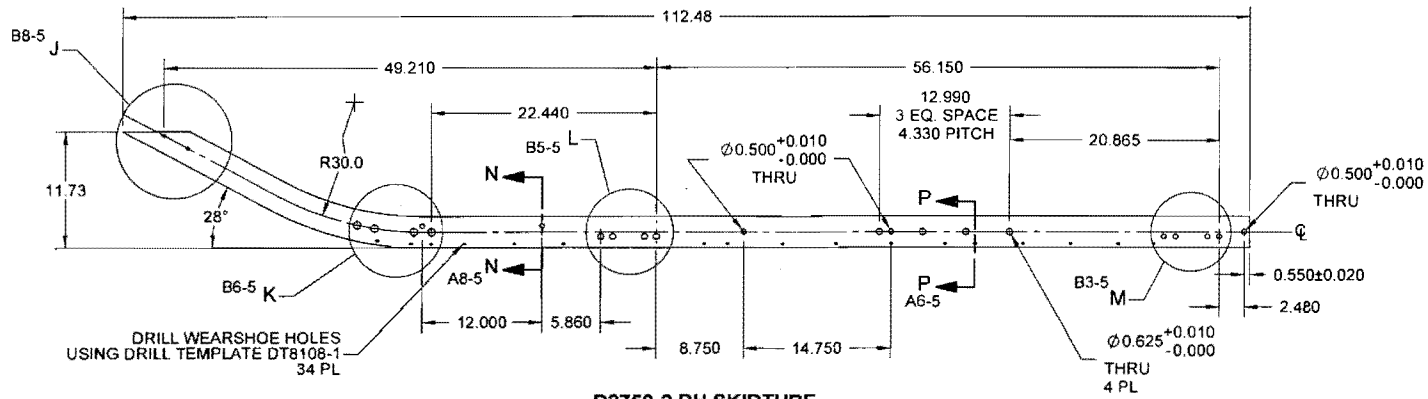


B2-4

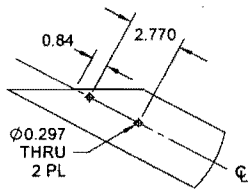
SECTION H-H
SCALE 3X, 4 PL

RELEASED

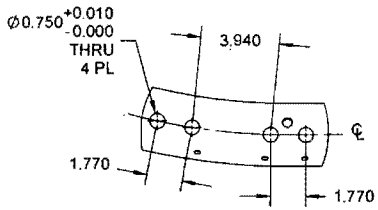
DESIGN	PM	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	PM	
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 4 OF 11
MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
APPROVED		
DE APPR.		
DATE	08.07.16	



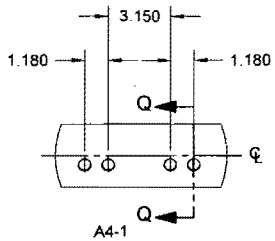
D2750-2 RH SKIDTUBE



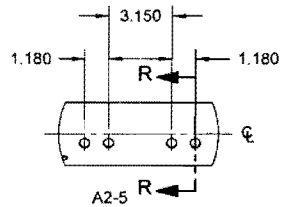
DETAIL J D8-5
SCALE 2X



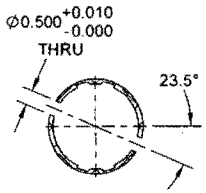
DETAIL K C7-5
SCALE 2X



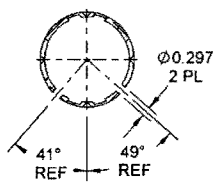
DETAIL L D6-5
SCALE 2X



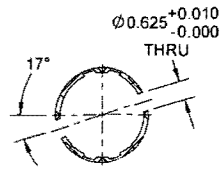
DETAIL M C3-5
SCALE 2X



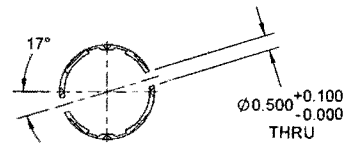
SECTION N-N C6-5
SCALE 3X, 2 PL



SECTION P-P C4-5
SCALE 3X, 17 PL



SECTION Q-Q B5-5
SCALE 3X, 4 PL



SECTION R-R B3-5
SCALE 3X, 4 PL

RELEASED
08/22/16

DESIGN	PEF	DART AEROSPACE USA, INC.	
DRAWN	PEF	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 5 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
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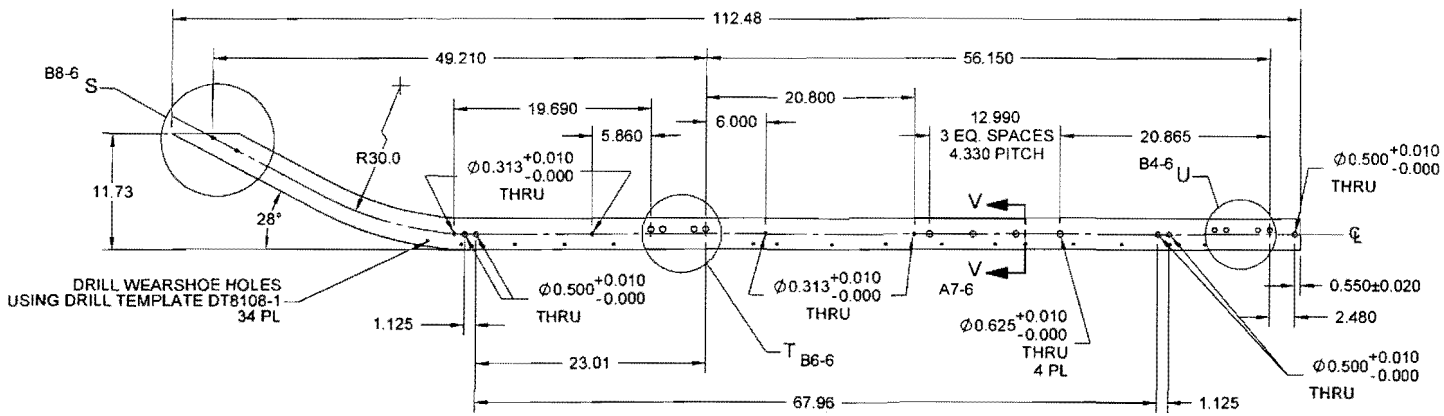
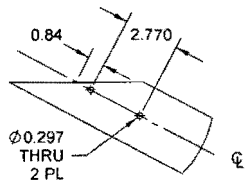
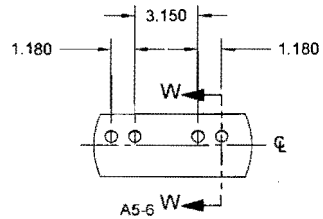
DATE 08.07.16			



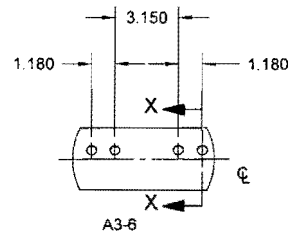
D2750-3 LH SKIDTUBE



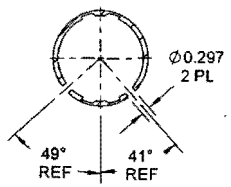
DETAIL S D8-6
SCALE 2X



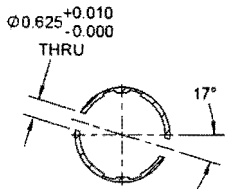
DETAIL T C5-6
SCALE 2X



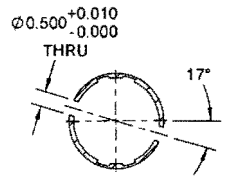
DETAIL U D3-6
SCALE 2X



SECTION V-V C4-6
SCALE 3X, 17 PL



SECTION W-W B6-6
SCALE 3X, 4 PL



SECTION X-X B4-6
SCALE 3X, 4 PL

RELEASED
08-09-16

DESIGN		**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 REV. F
MFG. APPR.		SHEET 6 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
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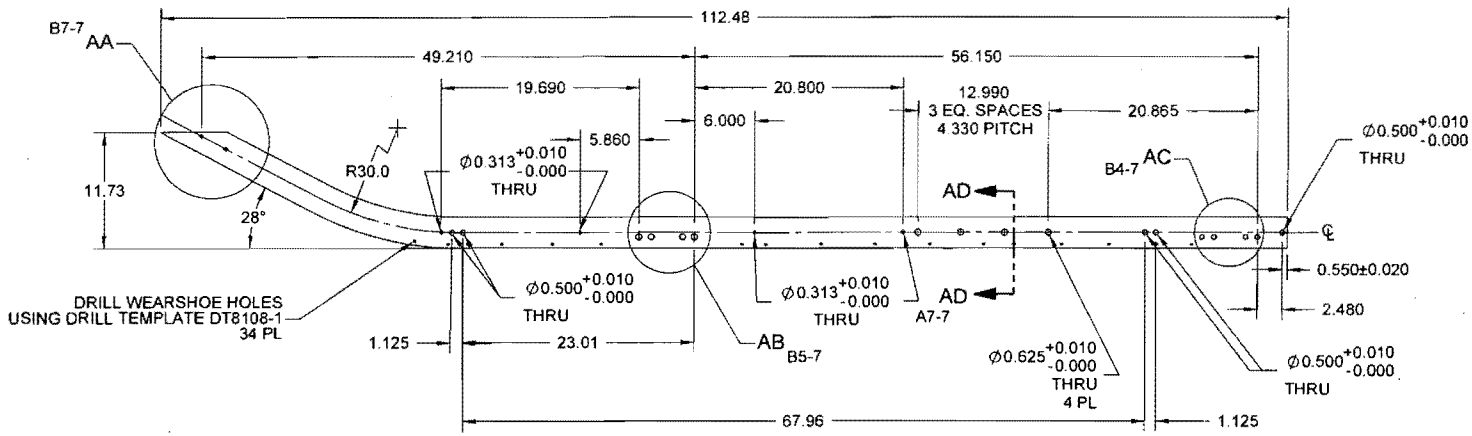
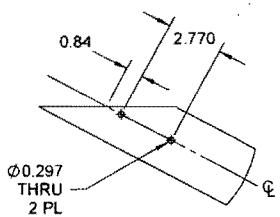
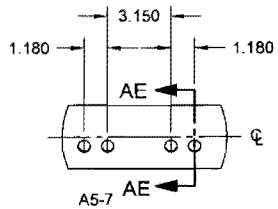
DATE 08.07.16		



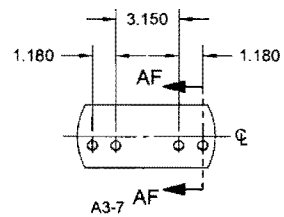
D2750-4 RH SKIDTUBE



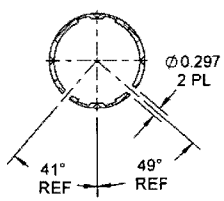
DETAIL AA D7-7
SCALE 2X



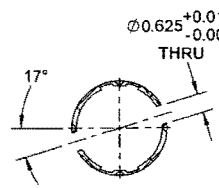
DETAIL AB C4-7
SCALE 2X



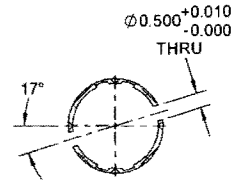
DETAIL AC D3-7
SCALE 2X



SECTION AD-AD D3-7
SCALE 3X, 17 PL



SECTION AE-AE B6-7
SCALE 3X, 4 PL



SECTION AF-AF B4-7
SCALE 3X, 4 PL

RELEASED
08.09.22

DESIGN	PH	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN		DRAWING NO. D2750 REV. F
CHECKED		SHEET 7 OF 11
MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
APPROVED		
DE APPR.		
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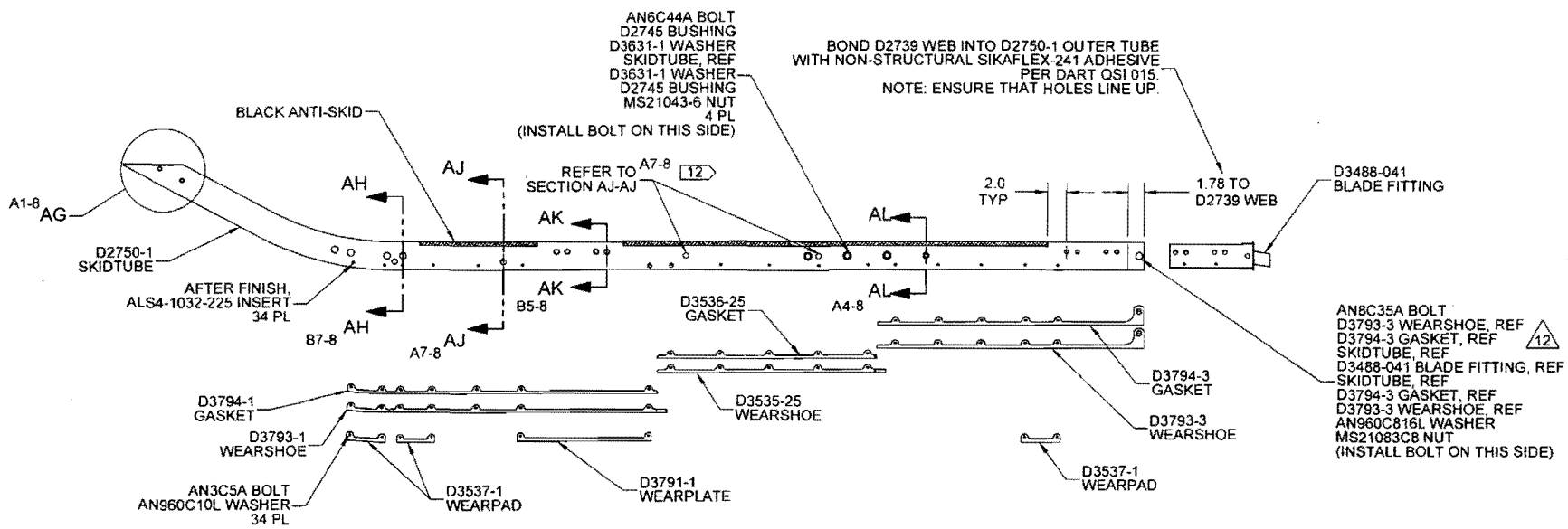
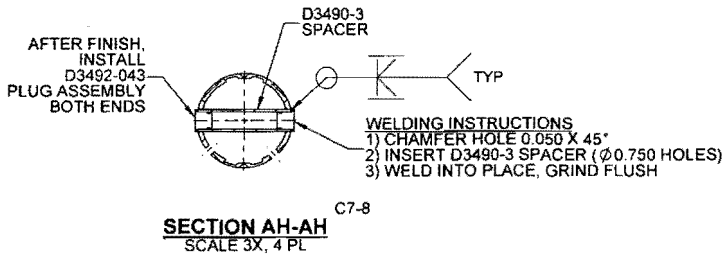
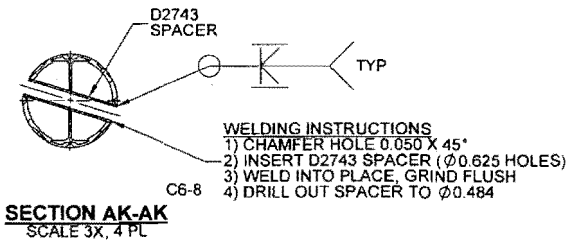


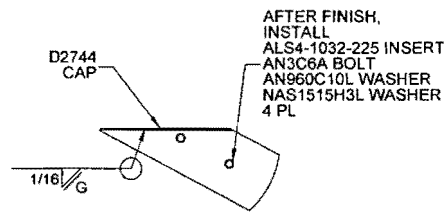
D2750-041 350 SKIDTUBE ASSEMBLY, LH



SECTION AH-AH
SCALE 3X, 4 PL

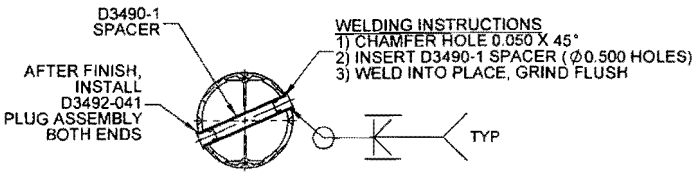


SECTION AK-AK
SCALE 3X, 4 PL

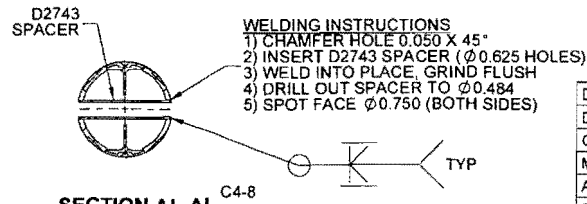


DETAIL AG
SCALE 2X
D8-8

RELEASED
08.09.22

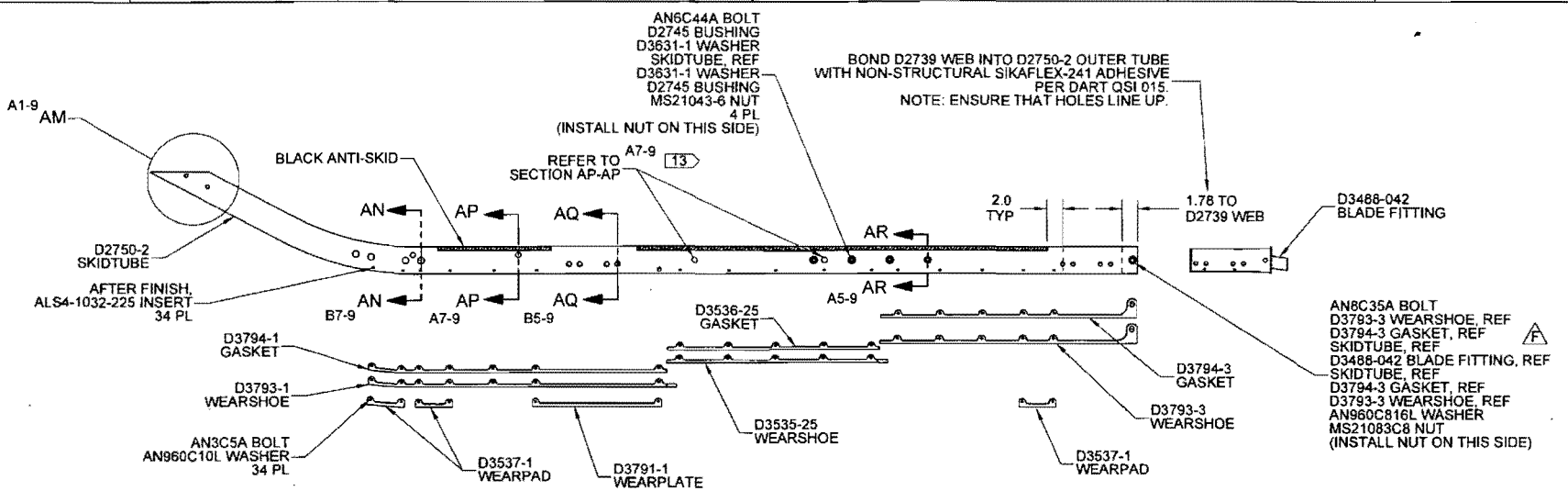


SECTION AJ-AJ
SCALE 3X, 4 PL

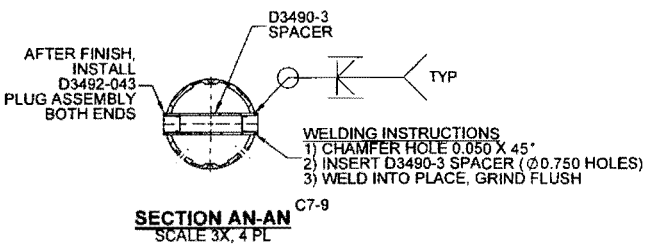


SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

DESIGN	RH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	RH	DRAWING NO. D2750 REV. F
CHECKED		SHEET 8 OF 11
MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
APPROVED		
DE APPR.		
DATE	08.07.16	

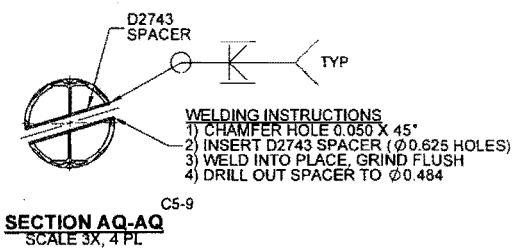


D2750-042 350 SKIDTUBE ASSEMBLY, RH



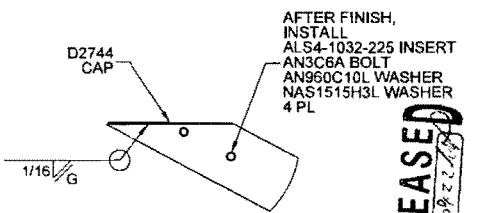
C7-9

SECTION AN-AN
SCALE 3X, 4 PL



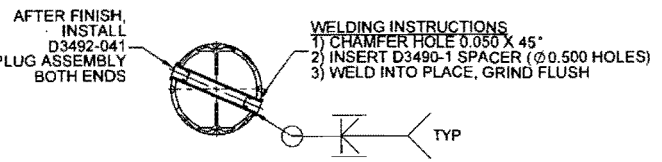
C5-9

SECTION AQ-AQ
SCALE 3X, 4 PL



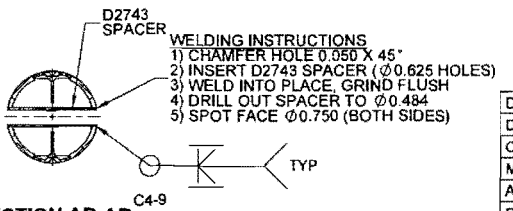
D8-9

DETAIL AM
SCALE 2X



C6-9, D5-9

SECTION AP-AP
SCALE 3X, 4 PL

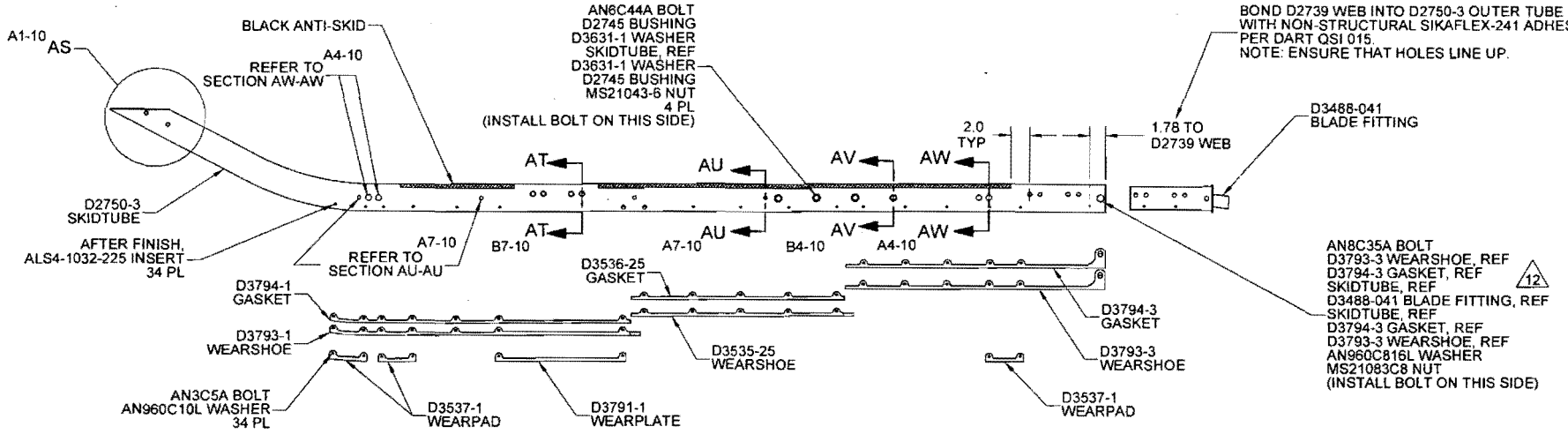


C4-9

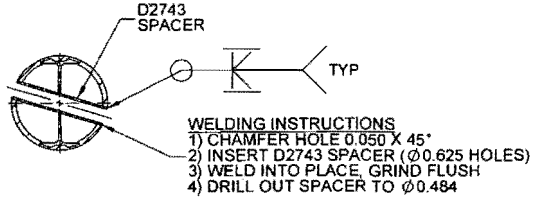
SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

RELEASED 08.22.16

DESIGN	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	PH	
CHECKED		DRAWING NO. D2750 REV. F
MFG. APPR.		SHEET 9 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.		
DATE 08.07.16		

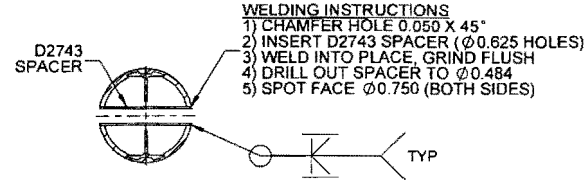


D2750-043 350 SKIDTUBE ASSEMBLY, LH



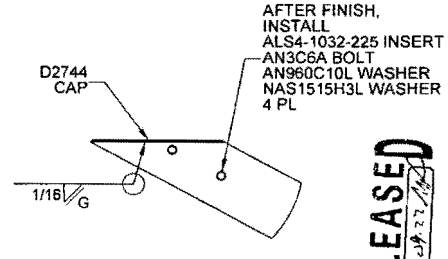
D6-10

SECTION AT-AT
SCALE 3X, 4 PL



D4-10

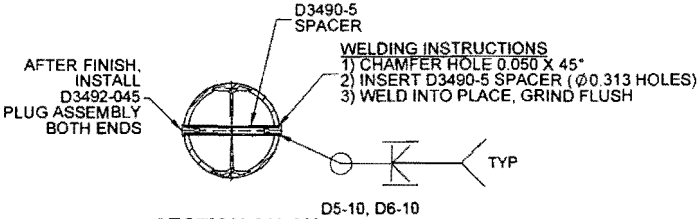
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



D8-10

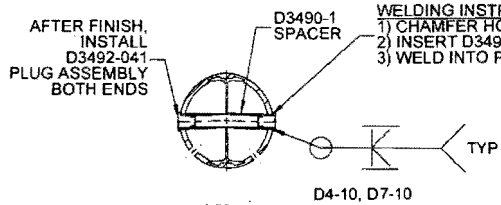
DETAIL AS
SCALE 2X

RELEASED



D5-10, D6-10

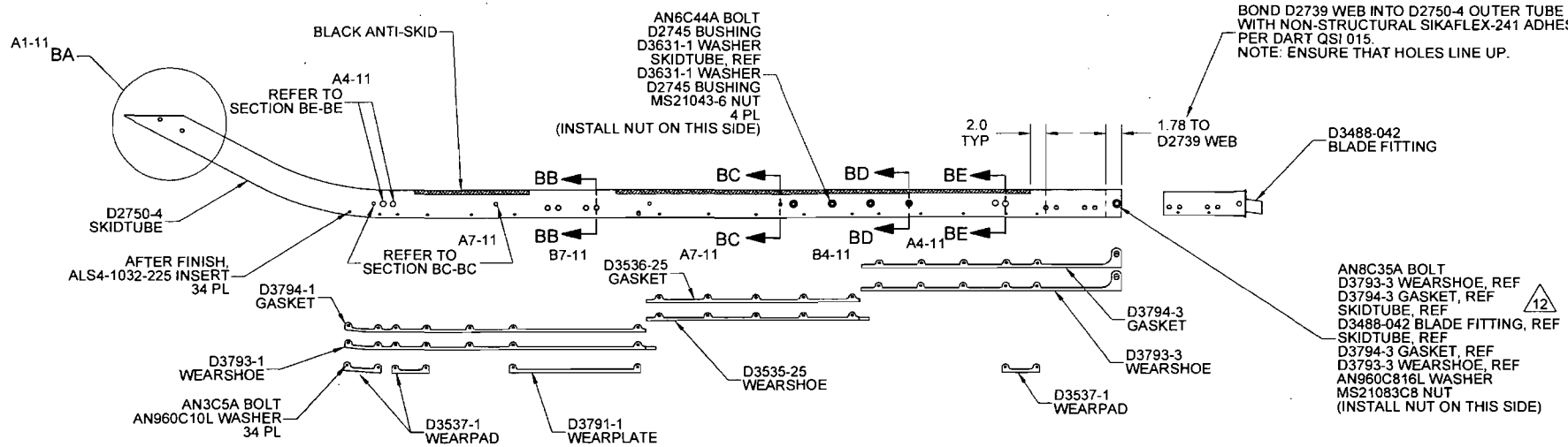
SECTION AU-AU
SCALE 3X, 4 PL



D4-10, D7-10

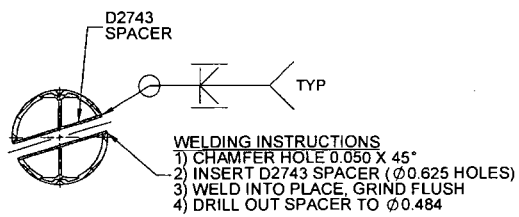
SECTION AW-AW
SCALE 3X, 4 PL

DESIGN		**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN		DRAWING NO. D2750 REV. F
CHECKED		SHEET 10 OF 11
MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
APPROVED		
DE APPR.		
DATE 08.07.16		



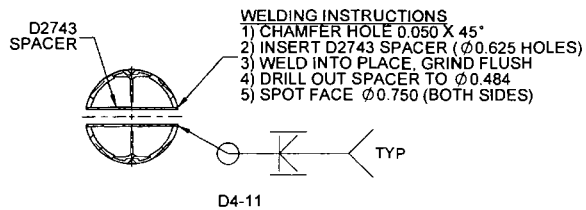
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
08.07.22 VM



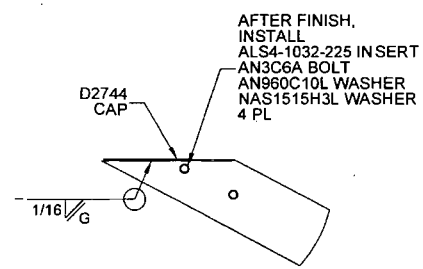
D6-11

SECTION BB-BB
SCALE 3X, 4 PL



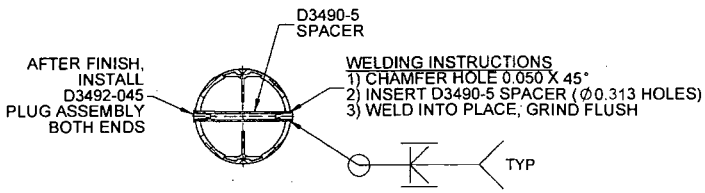
D4-11

SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



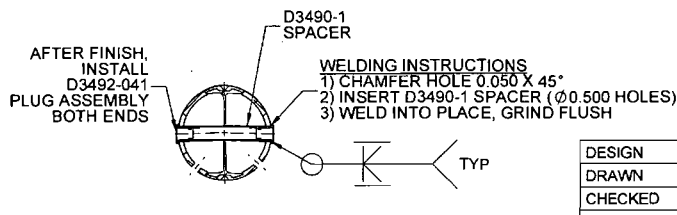
D8-11

DETAIL BA
SCALE 2X



D5-11, C6-11

SECTION BC-BC
SCALE 3X, 4 PL



D4-11, D7-11

SECTION BE-BE
SCALE 3X, 4 PL

DESIGN	AC	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	AC	
CHECKED		DRAWING NO. D2750 REV. F
MFG. APPR.		SHEET 11 OF 11
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DATE 08.07.16		